Work Order ID 89061 *89061* Page 1 August-21-12 12:55:49 PM D350-616-015 Accept Item 1D: *N900040100* Setup Start **Revision ID: Item Name:** Deck Plate Start Qty: 5.00 **Start Date:** 8/21/12 **Cust Item ID:** Req'd Qty: 5.00 Required Date: 8/31/12 **Customer:** Reference: Run Process Plan: MLJ Date: 17 108 7 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: **Tool ID** Tool # Plan Reject Reject Sequence ID/ Set Up/ Accept Operation Insp. Qty Number Stamp **Work Center ID** Description **Run Hours** Code Qty **Draw Nbr Revision Nbr** D350-616 Ε 100 *100* DC Memo Photocopy bluefile and create labels per PPP D350-616-015 Document Control CHG002 Pick Kit 0.00 110 *110* Packaging 0.00 Memo Packaging 120 QC4-100% Inspect kits for completeness *120* QC Memo Quality Control

. .

												DQA:	Da	ate:	935
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE					
												QA Closed:	Da	ate:	
Work Ord	er.					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Part I						Rework Scrap		ا	Skid-tube Machining	Crosstube Small Fab			Water Jet		Engineering Quality
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	Heat Treat Countersink					Maintenance Mislabeled					Positioned V	Mrong			
	Inspection Strip in Tube Cut Too Short					Misread					Power Loss/	•		Other	
						Drill Holes	Offset					I OMEL FOSS	Juige	L_	Joure
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Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Work Ord	der ID 89 12:55:49 PM	0061		*890				Page 2					
Item ID: Revision ID:	D350-616-0	15		Accept	*N900	040	100)*	Setup	Start	*N	S1*	
Item Name:	Deck Plate					,				Stop	*N	S2*	
Start Date: Required Dat	8/21/12 te: 8/31/12	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	D:							
Reference: Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
130 Packaging Packaging		Memo Identify and Location: PPP Rev:_	pack for shipping as per	0.00				5x				12	D 9-2:
140 *1 4 0*		QC21- Final Inspection	- Work Order Release	0.00					12	2/0	7/2	49	
QC Quality Control		Мето		0.00									

m 9-24

										D	QA:	Date:			
NCR: Y	'es	/ No				WORK ORDER NON-C	ON	NFORM	MANCE / UPDATE				Q		
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Work Orde	. r ·					DISPOSITION			AGAINST	DEPARTM	ENT/PR	OCESS			
WOIK OIGE	-					Rework			Skid-tube Crosstube		١	Water Jet	Engineering		
Part N	lo.					Scrap			Machining Small Fab			ng. Coor.	Quality		
	_					Use-as-is			noforming Finishing		'Store/P	ackaging	Other		
NCR N	lo			<u> </u>	 	Work Order Update			Large Fab Composite			Supplier			
Root	\neg				Descr	iption of work order update		nitial	Action	Sign	&				
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i	$\boldsymbol{-}$	Bending			<u>_</u>	Bend	Ш	Grain		Ovalize			Pressure/Forced		
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	-	Cracks				Broken/Damaged		Inspect	on Incomplete	Part Inc	orrect		Weld		
	Crushed/Crimped. Burrs							Instruct	ions Incomplete/Unclear	Part Los	st/Missin	g	Wrong Stock Pulled		
	Cuffs Contamination							Mainte	enance	Part Mo	oved				
	Heat Treat Countersink							Mislabe	eled	Position	ned Wroi	ng	-		
	Inspection Strip in Tube Cut Too Short						Misread Power Loss/Surge Other					Other			
	Ripples in Bend Drill Holes						Offset								
	Torque Waves in Extrusion Drawing							Out of (Calibration						
	Turning Sequence Finish							Out of Sequence							
	Wave/Twist in Tube Folio							Outside Dimensions							

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Picklist Print

August-21-12 12:55:48 PM

Work Order ID:

89061

Parent Item:

D350-616-015

Parent Item Name:

Deck Plate

Start Date: 8/21/12

Required Date: 8/31/12

Page 1

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:C

Removed Manufacturing 05-12-05 JLM Add D3494-1 05-12-05 JLM

IPP Rev:D IPP rev E

added parts per NCR 08-041 08.04.30

EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit Total Qty	Qty Issued	Date Issued	Status
AN960JD10 Washer	NAS1149D0363J	Purchased	No			110	Each	0.0000	122378	~2B		.e
D2344 Litter Deck Plate, 350		Manufactured	No			110	Each	6.0000	C1789132	13	Z	<u> </u>
4				Location		Loc Qty	<u>Lo</u>	c Code		0	(4)	1
.				ST224 8596	58	6			4785968			
D2348 Wearplate		Manufactured	No		~	110	Each	28.0000	97.2920	VAB	<u>_</u>	
				Location		Loc Qty	Lo	c Code			u	
				ST007		28						
				847:		1			10 T T 109			
				8822	29	27	. .	•	19+88229			
Stiffener		Manufactured	No			110	Each	5.0000	792095	JD.		<u> </u>
				Location		Loc Qty	Lo	c Code		,		
				ST224		3						
				8596	59	3						
				ST225		2						
` 1				794 ⁻	74	2						
D2364 Deck Plate, Fwd 350 Litt		Manufactured	No			110	Each	6.0000	X 89094	JB.	1	2/09/
~				Location		Loc Qty	<u>L</u> c	c Code		O	.~1	
				ST224		6						
				859	71	6			4×85971			

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPE	DATE		<u> </u>	•
											QA Closed:	Date:	<u> </u>
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	Vo.					Rework Scrap Use-as-is		t Therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
NCR I	No.					Work Order Update Large Fab Composite S							
Root					Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause	Date Step Qty or Non-conformance Chief Eng Description							iption	Date	Verification	QC Inspector		
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Training													
Unapproved													
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		Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S BOM/Route							Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	Inspection Incomplete					ct	Weld
	Crushed/Crimped. Burrs						Instructions Incomplete/Unclear			Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs					Contamination]Mainte	enance		Part Moved		
	Heat Treat Countersink					Mislabeled				Positioned Wrong		_	
	Inspection Strip in Tube Cut Too Short					Misread				Power Loss/Surge		Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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August-21-12 12:55:48 PM

Work Order ID: Parent Item:	89061 D350-616-015 Deck Plate							Date: 8/21/12		Required Date: Required Qty:	
Parent Item Name:	Deck Plate	Manufactured	No		110	Each	14.0000	Qty: 3.00	10		3.00 ISO
Wearplate				Location	Loc Qty		Loc Code	<u> </u>		- JO	<u> </u>
				ST008	14		<u> Doc coue</u>				
)				85781	14			85	781		,
D2369-1 Deck Plate Locator Brack	ets	Manufactured	No		110	Each	5.0000	2789		~ JB	
>				<u>Location</u>	Loc Qty		Loc Code			ŭ	E-00
				ST241A	5						
				85972	5			31859	772		
D2369-3 Deck Plate Locator Brack	ets	Manufactured	No		110	Each	3.0000	9×89	4145	133	_ % _
,				Location	Loc Qty		Loc Code			V	•
				ST241A	3						
				85973	3			1485	973		
D3494-1 Stub Cover		Manufactured	No		110	Each	8.0000		5	29	_a@p_
				Location	Loc Qty		Loc Code			• /	
				ST224	8		-				
				86034	8			- 86	034		
MS20426AD4-5 Rivet		Purchased	No		110	Each	4,361.0000	235	125	18	_S.O`_
				Location	Loc Qty		Loc Code			V	#000
				ST317	4361						
				6874	4361			68	374		
MS20426AD4-6 Rivet		Purchased	No		110	Each	1,255.0000	25	125	JB	12/09/
				Location	Loc Oty		Loc Code			S	•
4., . <u>.</u>				ST317	1255					.	
				110139	187						
				118510	13						
				119436	85			777	108		
. 15				121708	970			101	100		

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NCR: Y	es	/ No					WORK ORDER NON-C	O	NFORM	MANCE / UPDA	ATE	_		,
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Work Orde	T: —					١	Rework	1 		Skid-tube	Crosstube	I	Water Jet	Engineering
Part N	o					-	Scrap Use-as-is		ı	Machining noforming	Small Fab Finishing	4	d. Eng. Coor.	Quality
NCR N	o						Work Order Update			~⊢—	Composite	, Rec/stor	Supplier	- Other
Root					Descr	rip	tion of work order update		nitial	Actio	n	Sign &		
Cause		Date	Step	Qty	يند	OI	r Non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector
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		Bending				\neg	Bend		Grain			Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to	o/s	٦	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks Broken/Damaged						Broken/Damaged		Inspect	ion Incomplete		Part Incorred	:t [Weld
	Crushed/Crimped. Burrs						Burrs		Instruct	ions Incomplete/Un	clear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs Contamination						Contamination		Mainte	enance		Part Moved		
	Heat Treat Countersink						Countersink		Mislabe	eled		Positioned V	Vrong	
	Inspection Strip in Tube Cut Too Short						Cut Too Short		Misread	d		Power Loss/	Surge	Other
[Ripples in Bend Drill Holes						Drill Holes		Offset					
	Torque Waves in Extrusion Drawing						Drawing		Out of (Calibration				
	1	Turning Se	equence				Finish		Out of	Sequence				
	\neg	Wave/Twi	st in Tub	oe .			Folio		Outside	Dimensions				

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795 122452 795 ST300 728 117885 32 119017 558 119075 138 ST317 1712 2214 122141 1712

316

NCR:	Yes	/	No	

DQA: Date:

NCR:	⁄es	/ No				WORK ORDER NON-	COL	NFORN	//ANCE / UI	PDATE			
											QA Closed:	Date:	
Work Ord	ər.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part 1						Rework Scrap	-		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR I	No.					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
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Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng Description			Date	Verification	QC Inspector
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	_	Centre No	ot Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under		Temperature/Cure
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	<u> </u>	Cuffs			<u> </u>	Contamination	_	Mainte			Part Moved		
	<u> </u>	Heat Trea			L	Countersink	_	Mislabe		<u> </u>	Positioned V		-
		Inspection	•	Tube	<u> </u>	Cut Too Short	_	Misread	1		Power Loss/	Surge	Other
		Ripples in			L	Drill Holes	Offset						
	_	Torque W			n	Drawing	<u>_</u>	-1	Calibration				
	Turning Sequence Finish						Out of Sequence						
Wave/Twist in Tube Folio Outside Dimensions													

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August-21-12 12:55:49 PM

Work Order ID:

89061

Parent Item:

MS24693-@273

D350-616-015

Parent Item Name:

Deck Plate

110 No Each 279.0000

Start Date: 8/21/12

Required Date: 8/31/12

Start Qty: 5.00

Required Qty: 5.00

93-@273	Purchased	No		110	Each	279.0000	<u>6</u>)	30	V J.B	<u> </u>
		Locat	tio n	Loc Qty		Loc Code			0	家
		304		54				- 1 - 1 1		
			122441	54			12:	2441		
		ST310	0	225						
			120308	23						
			121060	2						
			122539	200						
93-C48	Purchased	No		110	Each	55.0000	92×122 18×122	110	13	%
		Locat	<u>tion</u>	Loc Qty		Loc Code	18×122	.993	,	
		304		55						
			122441	55						
07-264	Purchased	No		110	Each	31.0000	<u> </u>	20	·	10/20110

5,	M\$3\$207-264
102	Screw

Loc Code

20

Location Loc Qty ST294 31 31 121415

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Work Orde	p-				DISPOSITION		• .		AGAINST DE			•
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NCR N	0				Work Order Update	」	Large F	ab	Composite	j	Supplier	
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Initi Chief	1	Actio Descrip		Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
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Landin F	 1				General					7 0 . 11 4		70/5
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Ins Ins Ma Mi: Off	arn rdware pection Incor tructions Incor aintenance slabeled sread set t of Calibratio	omplete/Ur	nclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Turning Sequence Finish						t of Sequenc	· o			•	

Outside Dimensions

Wave/Twist in Tube

Folio

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REFERENCE ONLY

QTY - 011	Qty – 013	Qty – 015	Part Number	Description	
Х			D350-616-011	Full Litter Kit	
1	Х		D350-616-013	Deck Plate and Tie Down Kit	
1		Х	D350-616-015	Deck Plate Kit	
		1	D2344	DECK PLATE (AFT)	
	ı	4	D2348 /	WEAR PLATE (KEY WAY)	
	(1	.D2353 🖍	STIFFENER	
	1 D2360 LITTER TIE		LITTER TIE DOWN (LOCKING)		
1 D2364 > 62 2 - D2365		D2364	DECK PLATE (FWD)		
		2_2	-D2365	WEAR PLATE (PIP PIN)	
	\	1	*D2369-1-7	LOCATOR PLATE	
		1	D2369-3	LOCATOR PLATE	
1			D2370	LITTER ASSEMBLY	
1			D2493	PATIENT STOP	
	1		D3179-041	LITTER TIE DOWN (NON-LOCKING)	
		1	*D3494-1	STUB COVER	
		/ 25	MS20426AD4-5	RIVET	
		725	MSZ0426AD4-6	RÍVET	
		6	MS20426AD5-7	RIVET	
		7 6	MS20426AD5-8""	*RIVET	
		7 15	MS20601AD4W2		
		7 30	MS20601AD4W3	BEIND RIVET (or CR9162-4-3)	
		6	MS21042L3 /	NUT (or MS21042-3)	
		6	MS24693-C273 7	SCREW (or MS24693-273)	
		722	™S24693-C487	SCREW (or MS24693-48)	
) 4	MS35207-264 /	SCREW	
	É	10	NAS1149D0363J	WASHER (or AN960JD10)	



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROYED

BY: D. SHEPHERD (DE # 02)

DATE: 08.11.07 CERT. NO.: SH96-10

ISSUE NO.: 2

E	REPLA	CES D2350	RF	08.11.07	
D	ADD D	3494-1 STUB (МВ	06.01.19	
С	ADD D	SI 9112/9117/9	MB	06.01.10	
В	ADD V	EW OF D2493	BW	96.01.09	
Α	NEW IS	SSUE	BW	95.02.20	
REV.		ſ	BY	DATE	
DESIGN		BW	DART AEROSPACE LTD		LTD
DRAWN		RF	HAWKESBURY, ONTA	RIO, CANA	DA
CHECKED		DS	DRAWING NO.	REV. E	
MFG. APPR.		N/A	D350-616 SHEET 1 OF 12		HEET 1 OF 12
APPROVED		DS,	TITLE	SCALE	
DE APPR.		d	AS350/355 LITTER KIT INSTALLATION NTS		
DATE	08.1	1.07	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPLETE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		

MAKE DSI 9310 STANDARD; D3179-041